

Date: Tuesday, 7/1/2008 11:36:55 AM
 User: Kim Johnston

Process Sheet

| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : SPACER |
| Job Number : 40152 | |
| Estimate Number : 10165 | |
| P.O. Number : | Part Number : D25255 |
| This Issue : 7/1/2008 S.O. No. : | Drawing Number : D2525 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 7/1/2008 Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : 34521 | Material : |
| Written By : | Due Date : 7/22/2008 Qty: 80 Um: Each |
| Checked & Approved By : <u>08.07.01</u> | |
| Comment : Est C 02.08.22 Make in Cobra KJ/RF | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------|-------------------------|
| 1.0 | M6061T6R0750 | 6061-T6 Round Bar .750" |
|-----|--------------|-------------------------|



Comment: Qty.: 0.0218 f(s)/Unit Total : 1.7472 f(s)

6061-T6 Round Bar .750

Make as per Dwg D2525 and Folio FA261.

Material: 5052-H32 (QQ-A-225/7) or 1100 (QQ-A-225/1) or 6061-T6 (QQ-A-225/8) or 6061-T6 (QQ-A-200/8)

Ø0.75 Rod(M5052H32R0.750) or (M6061T6R0.750)

Batch 1103857

08/07/05

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

1-Turn Blank as per Dwg D2525

2-Deburr

DJP/mmr 08/07/05

86

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP/mmr 08/07/05

86

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

MR 08/07/06

80

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-07-07

80

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 11:36:55 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 40152

Part Number: D25255

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST PPP. 40151

JS 08/07/07

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.07.08

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

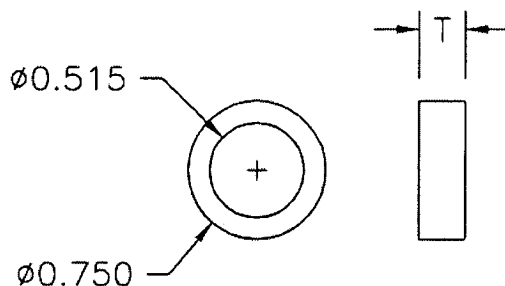
NOTE: Date & initial all entries



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN BW | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED KE | APPROVED RF | DRAWING NO. D2525 | REV. B SHEET 1 OF 1 |
| DATE 99.09.30 | | TITLE SPACER KIT | SCALE 1:1 |
| A | 95.12.22 | NEW ISSUE | |
| B | 99.09.30 | REVISED MATERIAL | |

RELEASED
99.10.12 KE

| PART NUMBER | THICKNESS T | QTY |
|-------------|-------------|-----|
| D2525-1 | 0.750 | 1 |
| D2525-3 | 0.250 | 1 |
| D2525-5 | 0.125 | 4 |
| D2525-7 | 0.063 | 0 |
| D2525-9 | 0.032 | 0 |



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40152

MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1